



Commercial Performance Coatings

ALK-110

CPC169

Industrial Alkyd Enamel

PRODUCT DESCRIPTION	
ALK-110 Industrial Alkyd Enamel	
TYPE: Alkyd Enamel RECOMMENDED USE ALK-110 is recommended for industrial use on primed or un-primed metal surfaces. Suitable applications include metal fabrication, castings, machinery and heavy equipment. This product can be tinted with the CPC tints.	
PHYSICAL CONSTANTS	
WEIGHT PER US GALLON (varies by color) 7.90 - 9.90 lb./gal PERCENT SOLIDS BY WEIGHT (varies by color) 48.8% ± 8.0% PERCENT SOLIDS BY VOLUME (varies by color) 36.0% ± 5.0%	FLASH POINTS ALK-110 Pensky-Martens 73°F (23°C) VOC (varies by color) 5.0 lb./gal maximum (unblended)
READY TO SPRAY VISCOSITY (varies by color) #3 Zahn 48 – 57 seconds #2 Zahn N/A	
PERFORMANCE FEATURES	
PENCIL HARDNESS HB-H (varies by color) FLEXIBILITY (Conical mandrel) Pass FADE RESISTANCE Good 100 HOUR HUMIDITY RESISTANCE Good	SHEEN ALK-110 is supplied as a gloss finish (80-90) on a 60° gloss meter. ADHESION 5B Excellent IN SERVICE TEMPERATURE LIMITATIONS 180°F(82°C) Maximum Note: Depending on the pigmentation, the color may change, but film integrity will be maintained until 150°F(65° C).
CHEMICAL/SOLVENT RESISTANCE	
200 HOURS SALT SPRAY	Good
WATER RESISTANCE: Resistant to intermittent exposure. Not recommended for immersion service	
SURFACE PREPARATION	
The surface to be coated must be clean and free of all contamination including dust, dirt, oil, grease and oxidation. Chemical treatment or the use of a conversion coating will improve the adhesion and performance properties of the finished coat.	



APPLICATION DATA

MIXING DIRECTIONS

STIR THOROUGHLY BEFORE AND OCCASIONALLY DURING USE

THINNING

Thin with Aromatic 100, Glycols, or Xylene as needed.

RECOMMENDED WET FILM BUILD (unreduced)

Spray or roller application: 4.0 - 5.7 mils

RECOMMENDED DRY FILM BUILD

Spray or roller application: 1.4 - 2.0 mils

APPLICATION EQUIPMENT

Roller: 3/8 nap solvent resistant

Brush: For touch up-uses only. High Quality Natural Bristle

Spray: **Conventional**- DeVilbiss MBC-510 or JGA gun, 704 or 777 air cap with "E" tip and needle or equivalent equipment. Atomizing pressure 30-60- psi.

HVLP- DeVilbiss GTI or Plus gravity gun. 1.3 or larger fluid tip. Atomizing pressure 10 psi at the air cap.

Airless Spray: Equipment capable of maintaining a minimum of 1400 psi at the tip without surge. 0.011" (0.279mm) to 0.015" (0.47mm) orifice.

DRYING TIME

At 77°F (25°C) and 50% relative humidity.

To Touch: 10-20 minutes

To Handle: 45-60 minutes*

Dry: 24 hours**

Re-coat: Before 4 hours or after 72 hours.

Force Dry: Allow 10 minutes air dry then bake 20 minutes @ 160°F (71°C)

* This condition does not mean that the paint film has reached full cure. It is a stage where handling can be achieved without loosening, wrinkling or otherwise marring the film under minimal pressure from fingers or hands. Drying time listed may vary depending upon film build, color selection, temperature, humidity and degree of air movement.

** Paint film is not fully cured for 7 days.

Application of film thickness in excess of that recommended for this product will substantially extend dry time and lengthen the re-coat window. Excess film may also cause problems such as adhesion failure, pigment floatation, solvent popping, slow cure, and accelerated gloss and color failure

RECOMMENDED SPREADING RATE

513-642 sq. ft. at 1.0 mil dry film per US gallon (varies by color). Coverage figures do not include losses due to mixing, transfer or application of coating or losses due to surface irregularities or porosity.

CLEAN UP

Acetone, MEK, Toluene, Xylene or Lacquer Thinner

APPLICATION PRECAUTIONS AND LIMITATIONS

Apply only when air, product or surface temperature is above 60°F (16°C) and when surface temperature is at least 5°F (3°C) above the dew point.

All Commercial Coatings Performance data is based on spray application at the recommended film build. If alternative application methods are employed, substrate preparation and film builds listed for spray application must be followed.

To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information

SAFETY

These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public.

Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.

PRECAUTIONARY INFORMATION

Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

KEEP OUT OF THE REACH OF CHILDREN

MEDICAL RESPONSE

Emergency Medical or Spill Control Information (412) 434-4515. CANADA (514) 645-1320 Have label information available. **Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor. For ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.**

PPG Industries
Commercial Coatings

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